

Date: Wednesday, 12/13/2006 2:41:36 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 29922D		
Estimate Number	: 10356		
P.O. Number	: N/A	Part Number	: D2279
This Issue	: 12/13/2006 S.O. No. : N/A	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: D
Previous Run	: 28791D	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 1/5/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>[Signature] 061213</u>		
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s)  
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
 (M2024T3S.040)  
 Identify as D2279  
 Batch: 1101422 M103028

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D 2279  
 Dwg Rev: D  
 Prog Rev: D

2-Deburr if necessary

SAP 06:12:28 (20)

SAD 06:12:28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:12:28 (20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07.01.02 (20)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Form As per Dwg D2279

SAP 07-02-14

07.01.12 (20)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2279 PAR #: N/A Fault Category: Prod/Proc. Res <sup>... mfg of. Savant.</sup> NCR: Yes No DQA: Yes Date: 07/02/21  
 QA: N/C Closed: Yes Date: 07.02.21

NCR: <u>29922D</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/28	2.0	wrong material size. 0.032 was used Scrap; replace with correct material. Human error.	<u>AS1042</u>	Replace parts with 0.040" mat'l. Destroy 0.032. Ensure to measure the mat'l before using it.	<u>SAB</u> <u>06/12/28</u>	<u>07-01-02</u>	<u>06-12-08</u> <u>AS1042</u>	<u>06-12-28</u>

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:41:37 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 29922D

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*John. 14 (20)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*44 / a.m.*

*07-02-19 (20)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*167/2/19 (20)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*07/02/19 (20)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



*(20)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/02/21*

Job Completion



*11 07.02.21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	29922 D
<b>Description:</b> Step Spacer		<b>Part Number:</b>	D2279
<b>Inspection Dwg:</b> D2279	<b>Rev:</b> D	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.005	0.253	✓		Vern	
2.214	+/-0.005	2.216	✓		Vern	
4.178	+/-0.005	4.180	✓		Vern	
4.428	+/-0.010	4.428	✓		Vern	
0.250	+/-0.005	0.253	✓		Vern	
1.313	+/-0.005	1.312	✓		Vern	
3.313	+/-0.005	3.319	✓		Vern	
4.625	+/-0.010	4.624	✓		Vern	
Ø0.128	+0.005/-0.000	Ø0.130	✓		Vern	
Ø1.250	+0.005/-0.000	Ø1.251	✓		Vern	
R0.125	+/-0.010	R0.125	✓		<del>Vern</del> R-6	

<b>Measured by:</b>	JAD	<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06:12:28	<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	

**DART**



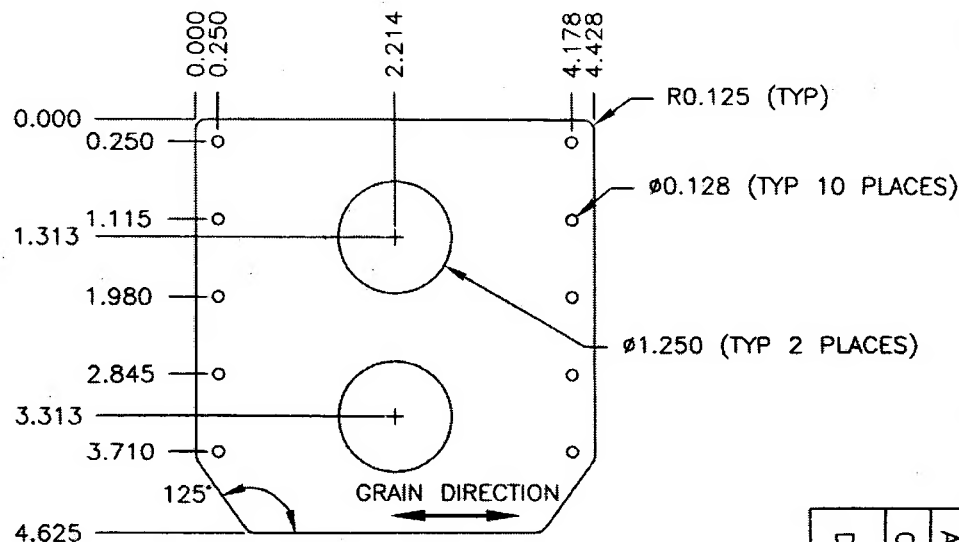
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
BW	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	JP	D2279	
DATE	TITLE	SCALE	
98.10.05	STEP SPACER	1:2	
A	C	D	
94.10.13	94.11.15	98.10.05	
NEW ISSUE	0.588 WAS 1.607 AND 3.861 WAS 4.881	4.428 WAS 4.460, 0.040 WAS 0.032	
		CHANGES PER TSR A912	

**RELEASED**  
98.10.08 DS

**UNDER REVIEW**

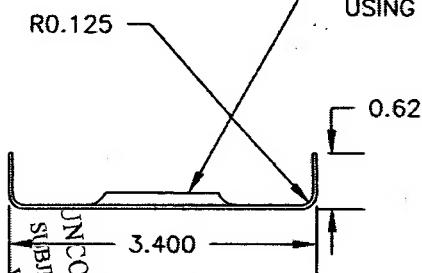
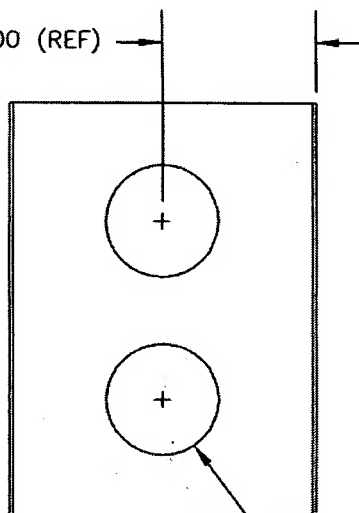
DESIGN OK, BUT CHECK WITH TS BEFORE MANUFACTURE

OK changes



FLAT LAYOUT

FLANGE AFTER BENDING TOWARDS INSIDE OF PART USING DT8174 (2 PLACES)



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER NO. 2222

